120

QC8- Inspect parts - second check

0.00

120

Memo

0.00

Quality Control

				i				•		DQA:	Date	:
NCR: Y	Yes / 1	lo		ı	WORK ORDER NON-C	ONFO	ORN	MANCE / UPDATE		0.4.61		
					7					QA Closed:	Date	:
NA Complete					DISPOSITION	1		AGAINST	DE	PARTMENT/	PROCESS	
Work Orde	er:			<u> </u>	Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	No.			I	Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is	TH		noforming Finishing		Rec/Stor	e/Packaging	Other
NCR N	No				Work Order Update			Large Fab Composite			Supplier	
				<u> </u>			. 1					
Root			1	1 1	iption of work order update	Initi		Action		Sign &		
Cause	Da	te Step	Qty		or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
Doc/Data		ŀ										
Equip/Tooling				1	•					t		
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Unapproved				1								<u> </u>
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Landi	ng Gear				General	_				7	_	7
	Bend	_		'	Bend	Gra			╙	Ovalized	· -	Pressure/Forced
	Centi	e Not Conce	entric to	O/S	BOM/Route	\vdash	rdwa		<u>_</u>	Over/Under		Temperature/Cure
	Crack	S			Broken/Damaged	—	-	on Incomplete		Part Incorre	 	Weld
	Crust	ed/Crimped	.		Burrs			ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\mathbf{H}		nance	<u></u>	Part Moved		
	Heat	Treat			Countersink	Mis	slabe	led		Positioned V	_	
, .	Inspe	ction Strip i	n Tube	i	Cut Too Short		sread	d		Power Loss/	Surge	Other
	Rippl	es in Bend			Drill Holes	Off	fset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Packaging

Packaging

February-14-13 2:45:01 PM Item ID: D3065-5 Accept *N900040100* Setup Start **Revision ID:** Item Name: Step Leg **Start Date: Start Qty: 30.00** 2/14/13 **Cust Item ID:** Required Date: 2/25/13 Req'd Qty: 30.00 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 130 Chemical Conversion Coat per QSI005 4.1 0.00 *130* HandFinish 0.00 Memo Hand Finishing 140 QC3- Inspect Part Finish 0.00 *140* QC 0.00 Memo Quality Control 150 Identify as per dwg & Stock Location 0.00 *150*

0.00

Memo

					,						DQA:	Date:	
NCR:	Yes	/ No			I	WORK ORDER NON-C	O	VFORM	MANCE / UPD/				
					1						QA Closed:	Date:	
Work Ord	or:				_	DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part f	_					Rework Scrap		Skid-tube Crosstube Machining Small Fab		—	Water J Prod. Eng. Cod		Engineering Quality
NCR I	No				!	Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update		nitial	Actio	on	Sign &	-	
Cause		Date	Step	Qty	! (or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC inspector
Doc/Data					1								
Equip/Tooling													
Operator					'				;				
Material							ļ						
Setup					. 1								
Other		i											
Process													
Supplier					:								
Training					!								
Unapproved					<u> </u>								
					-	FA	٩U١	T CATE	GORY				
Landi	ing G	ear			· ·	General		1			1	_	1 .
		Bending			1	Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route	L	Hardwa	re	<u> </u>	Over/Under	-	Temperature/Cure
		Cracks				Broken/Damaged		4	on Incomplete	ļ	Part Incorre	<u> </u>	Weld
		Crushed/0	Crimped.			Burrs	L	Instruct	ions Incomplete/Un	nclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs			1	Contamination	L	Mainte	nance		Part Moved		
		Heat Trea	t		1	Countersink	L	Mislabe	eled		Positioned \	Wrong	-
	П	Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence
Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

February-14-13 2:45:01 PM

Item ID: D3065-5 Accept *N900040100* Setup Start **Revision ID:** Item Name: Step Leg **Start Date:** 2/14/13 **Start Qty: 30.00 Cust Item ID:** Required Date: 2/25/13 Req'd Qty: 30.00 **Customer:** Reference: Run **Approvals:** Process Plan: Date: _____ Tooling: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 160 QC21- Final Inspection - Work Order Release 0.00 *160* 0.00 Memo Quality Control

M 13-00-119

												DQA:	Da	te:	
NCR:	Yes	/ No			1	WORK ORDER NON-C	100	NFORM	AANCE / UPD	ATE					
												QA Closed:	Da	te:	· · · · · · · · · · · · · · · · · · ·
Work Orde	or.				-	DISPOSITION				AGAINST I	ЭΕ	PARTMENT	PROCESS		
WOIR OIG	-				T	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part I	No.				,	Scrap			Machining	Small Fab	_	Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Therm	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR I	۷o.					Work Order Update			Large Fab	Composite [Supplier		
		•		Г					A -1:			Cian 9		_	
Root		_	_	_		ption of work order update	l	nitial	Acti			Sign &) /! : ! ! -	-	OC Imamastar
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	ption		Date	Verificatio	<u>n</u>	QC Inspector
Doc/Data	Щ													ļ	
Equip/Tooling	Ш				' I							,	·		
Operator					1										
Material															
Setup							ļ								
Other					i										
Process	Ш				i										
Supplier	Ш				:										
Training	Ш														İ
Unapproved			<u> </u>	<u> </u>			<u>L</u>								
				·		F	AUL	T CATE	GORY						
Landi	ng G	iear				General		1		,		1		_	1
		Bending				Bend		Grain				Ovalized		L	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	$ldsymbol{le}}}}}}$	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/U	nclear		Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	t			Countersink		Mislabe	led			Positioned V	Vrong		-
	П	Inspection	n Strip in	Tube		Cut Too Short		Misread	İ			Power Loss/	Surge	L	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

February-14-13 10:51:40 AM

Work Order ID:

97156

Parent Item:

D3065-5

Parent Item Name:

Step Leg

Start Date: 2/14/13

Required Date: 2/25/13

Page 1

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Rev.E. Now manufactured with 6061-T6 06-05-25 ILM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	393.7686	0.825	26. 0526 33 32	#01 # 3 7 Ne .#*		JM13-3-
				Location		Loc Qty	<u>Lo</u>	c Code					•
				MAT021		393.768632							
				117	285	0.248632							
				119	766	39.82							
				120	096	168.8							
				123	279	40.9							
				124	572	144			12	4572			

									DQA:	Date:	
NCR: Y	es / No			:	WORK ORDER NON-C	CONFORI	MANCE / UI		QA Closed:	Date:	
Work Orde	r			'	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is	- I	Skid-tube Machining moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Update		Large Fab	Composite	·	Supplier	
Root				De	scription of work order update	Initial	А	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
oc/Data											
quip/Tooling											
perator											
/laterial											
etup								1			
Other											
rocess	_					ļ					
upplier				'							
raining	_										
Jnapproved			1	<u> </u>					<u> </u>		<u> </u>
						AULT CATE	GORY				
Landin	ig Gear				General				-		-

dir	ng G	sear	General	 _		-		•
ſ		Bending	Bend	Grain		Ovalized		Pressure/Forced
		Centre Not Concentric to O/S	BOM/Route	Hardware		Over/Under tolerance		Temperature/Cure
Ī		Cracks	Broken/Damaged	Inspection Incomplete	L	Part Incorrect		Weld
Ī		Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled
		Cuffs	Contamination	Maintenance		Part Moved		
		Heat Treat	Countersink	Mislabeled		Positioned Wrong	_	- ,
Ī		Inspection Strip in Tube	Cut Too Short	Misread		Power Loss/Surge	L	Other
Ī		Ripples in Bend	Drill Holes	Offset				
		Torque Waves in Extrusion	Drawing	Out of Calibration				
Ī		Turning Sequence	Finish	Out of Sequence				· · · · · · · · · · · · · · · · · · ·
1		Wave/Twist in Tube	Folio	Outside Dimensions				

DART AEROSPACE LTD	Work Order:	97156
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	_		_		• -	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.455	<u></u>	-	+	Themale
15.750	+/-0.005	15.750"	_			
2.250	+/-0.005	2.254"	_		V	Ji-mo:
3.460	+/-0.005	3.462"	-		V	
0.865	+/-0.005	0.870	-		✓′	
6.020	+/-0.005	G.023'	-		V	
1.205	+/-0.005	1.207	-		V	
3.484	+/-0.005	3 485	-		V	
0.871	+/-0.005	0:875"	,		V	
8.325	+/-0.010	8.329"	-		V	Produsor
0.551	+/-0.010	0.555	-		V	
0.213	+0.005/-0.000	0.214	_		V	
Ø0.128	+0.005/-0.000	0.129			V	

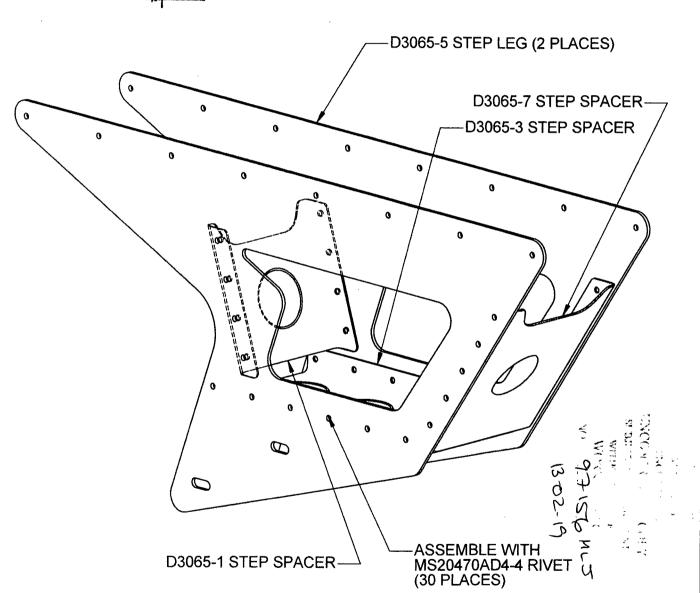
			()A(·	
Measured by:	JM	Audited by:	09	Prototype Approval:	N/A
Date:	13-3-16	Date:	13-03-18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	04.06.15	Added Ø0.128 dimension	KJ/JLM 1.A	2/
С	06.06.23	Dwg Rev. changed	KJ/JLM	411



DESIGN	8	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
CHECK	ED	APPROVED	DRAWING NO.	REV. B					
	PH		D3065	SHEET 1 OF 5					
DATE	06.0)E 00	TITLE	SCALE					
	00.0	05.23	STEP LEG ASSEMBLY	1:2					
Α	0:	2.09.11	NEW ISSUE						
B 06.05.23		6.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5						

RELEASED



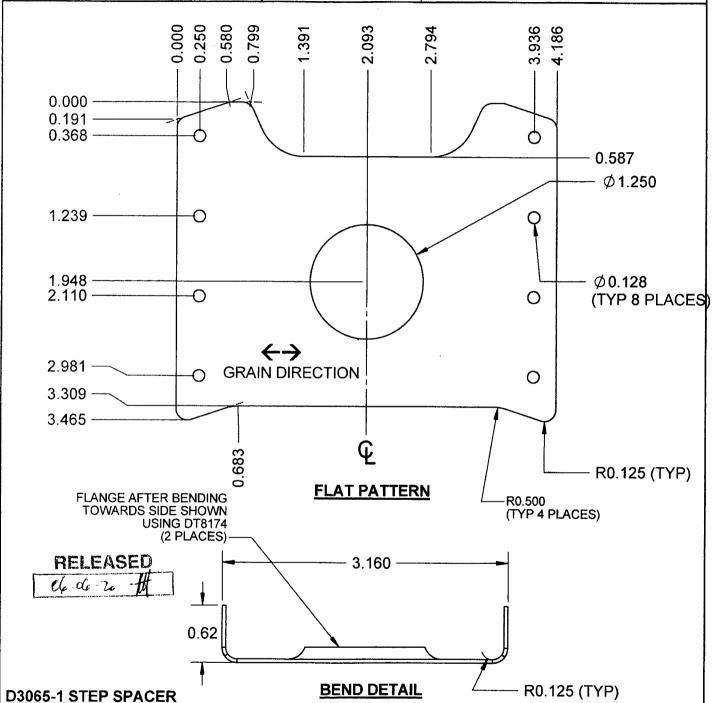
D3065-041 STEP LEG ASSEMBLY

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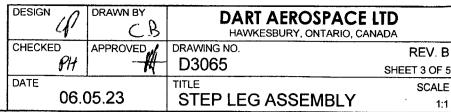
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

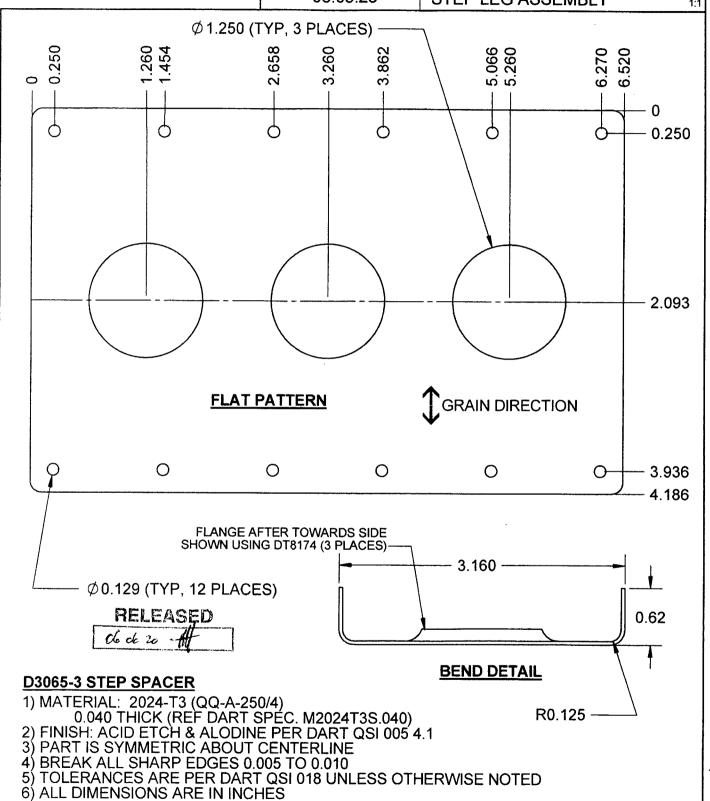
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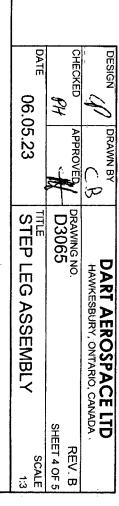
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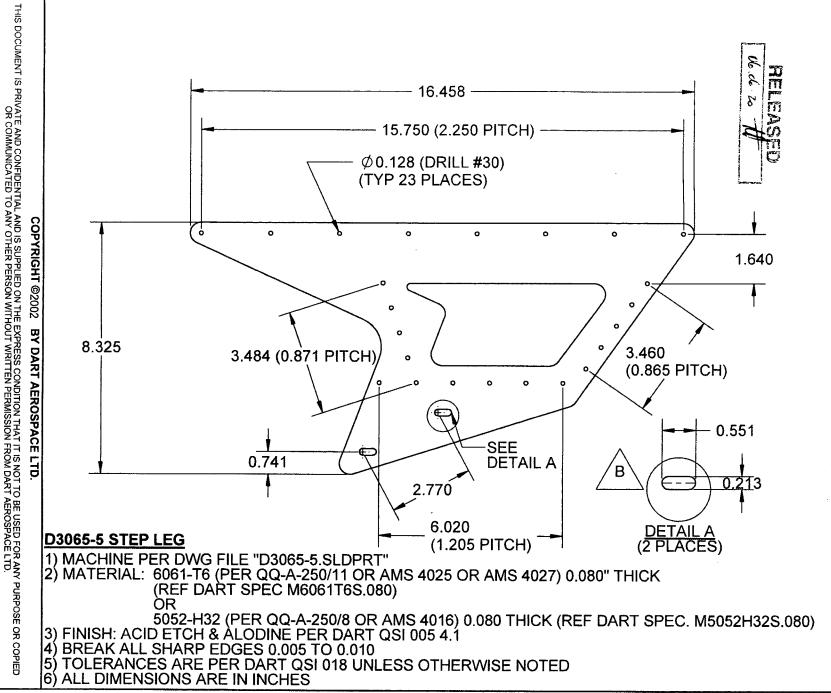
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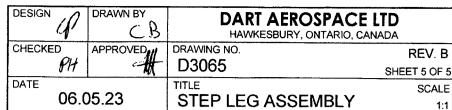
97156

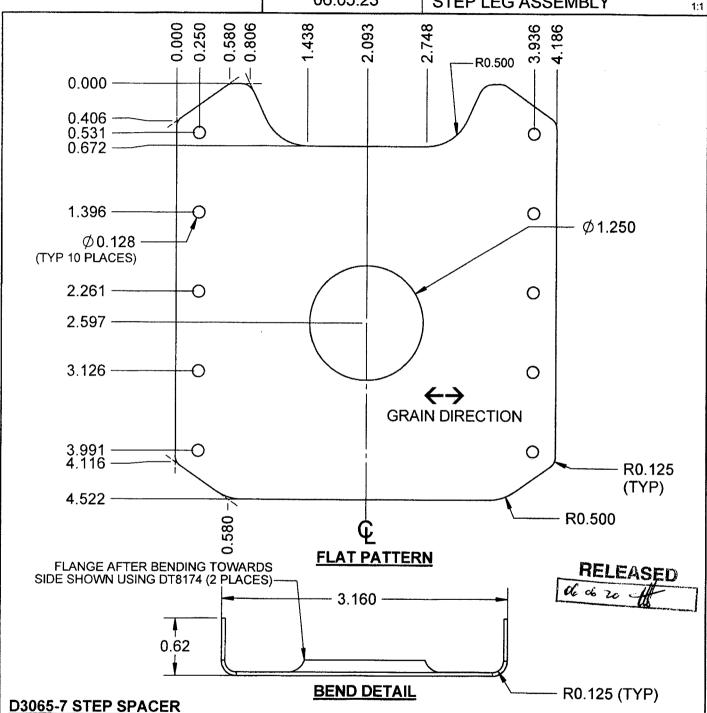
DART











- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
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